

Work Order ID 59642

Wednesday, June 09, 2010 9:46:50 AM



Page 1

Item ID:	D2935	Accept		Setup	Start	
Revision ID:						
Item Name:	Saddle Spacer				Stop	
Start Date:	6/9/2010	Start Qty:	30.00			
Required Date:	6/17/2010	Req'd Qty:	30.00			
Reference:						

Approvals:	Process Plan:		Date:	10-6-09	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2935	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2935								
6061 .080	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

10-6-09 (45)

10-6-09

8/26/09 (45)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2935

Accept



Setup Start



Revision ID:

Item Name: Saddle Spacer

Stop



Start Date: 6/9/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00							
	Hand Finishing								
140	QC3- Inspect Part Finish	0.00							
	QC	0.00							
	Quality Control								
150	Identify as per dwg & Stock Location	0.00							
	Packaging	0.00							
	Packaging								

Handwritten: 10 06 24 (45)

Handwritten: 45 BR 10-6-24

Handwritten: 10-6-25 SP (452)

Handwritten: changes

Handwritten: 22

W/O:		WORK ORDER CHANGES					
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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28 *[Signature]*
CL 10/6/25

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Picklist Print

Wednesday, June 09, 2010 9:46:54 AM

Page 1
T

Work Order ID: 59642



Parent Item: D2935

Parent Item Name: Saddle Spacer

Start Date: 6/9/2010

Required Date: 6/17/2010

Comments: IPP A ☐ 00.06.06 ☐ New Issue ☐ EC ☐
IPP Rev:B Now 6061-T6 06-06-23 JLM

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	156.8419	0.0507	1.601053	2.3		
6061-T6 .080 Sheet													



HB 10-6-23

Location

Loc Qty

Loc Code

MAT21

156.84193

113438

2.7512

114351

154.09073

114351

(42)

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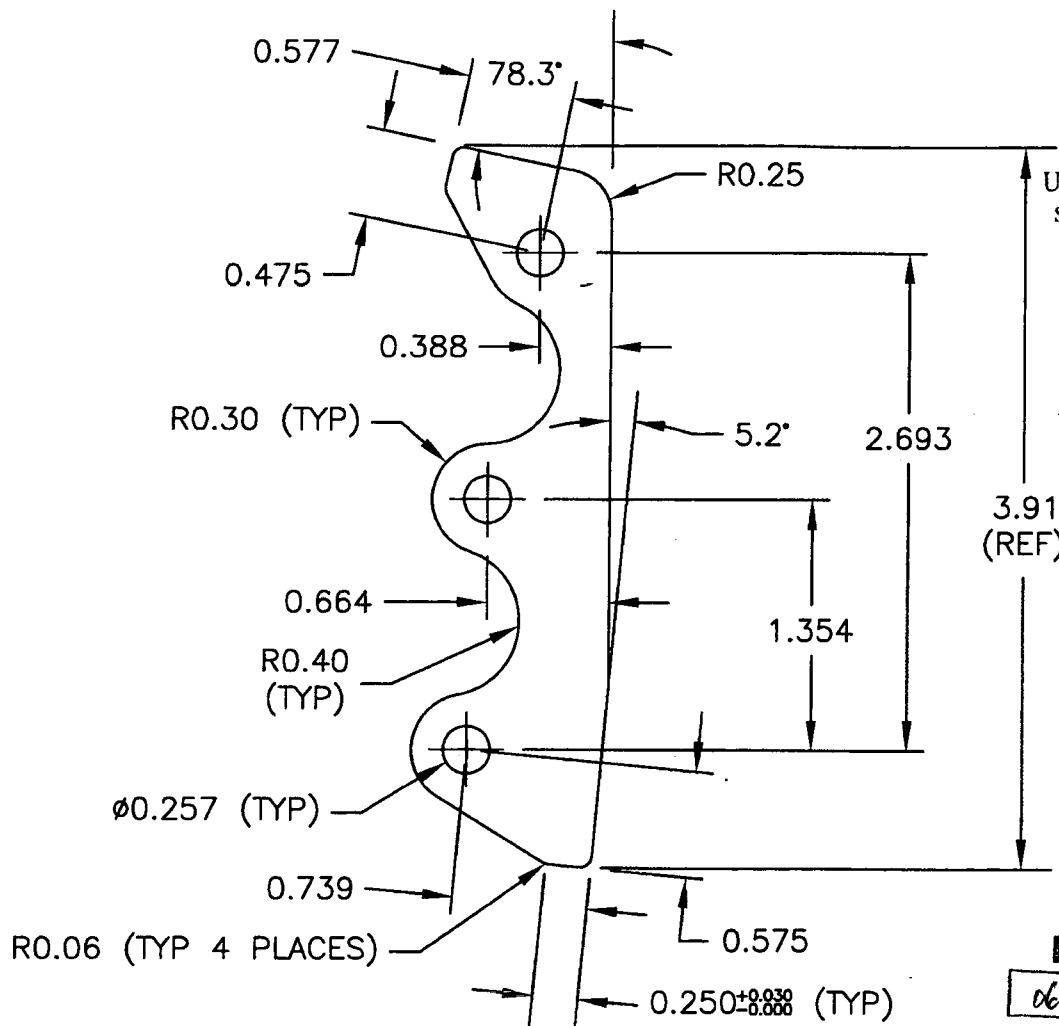
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DART

DESIGN 7#	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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